



Dart Aerospace Ltd.
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D4292-1
Job Sheet 178115



Part No: D4292-1

Job Qty: 4 ea

Part Name: Fitting



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/26/18

Job Tracking No:

Due Date: 5/31/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP REV:A NEW ISSUE 10-11-14 JLM VERIFIED BY:DD IPP REV B: AS PER REV B 11-02-15
JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	5/31/18	5/31/18	0.00	0.00	Start Up Machining-2		
100	Bandsaw	4 pcs	5/31/18	5/31/18	0.00	0.34	Bandsaw1		
110	CNC Vertical Machining	4 pcs	5/31/18	5/31/18	0.51	8.23	HAAS 5 Axis		
120	QC	4 pcs	5/31/18	5/31/18	0.00	0.00	QC2 Machining-2		
130	QC	4 pcs	5/31/18	5/31/18	0.00	0.00	QC8 Machining-2		
140	HandFinish	4 pcs	5/31/18	5/31/18	0.00	0.22	HandFinish1		
145	Powdercoat	4 pcs	5/31/18	5/31/18	0.00	0.30	Powdercoat1		
150	QC	4 pcs	5/31/18	5/31/18	0.00	0.00	QC3		
151	Small Fab	4 pcs	5/31/18	5/31/18	0.00	0.18	Small Fab-6		
152	QC	4 pcs	5/31/18	5/31/18	0.00	0.00	QC5		
180	Packaging	4 pcs	5/31/18	5/31/18	0.00	0.00	Packaging3-2		
190	QC21-SA	4 Ea	5/31/18	5/31/18	0.00	0.00	QC21		

Part Op 100 - Cut Blank to 6.250" ****GRAIN DIRECTION MUST BE ALONG 4.00"*****

Descriptions: 110 - 1-Machine per folio FB002

145 - MASK THREADED HOLE

151 - INSTAL HELICOIL

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T73B4.000x4.000	7075-T73 Bar 4.0 X 4.0 Grain Direction Along 4" Wide	2.0800 ft (.52 ea)	90-Start up Operation	S080 138
MS21209F1-10	Heli Coil	4 Ea (1 ea)	151-Small Fab	S0 44218

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T73B4.000x4.000	2	36	0
151-Small Fab	MS21209F1-10	4	36	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fitting	0.063Inches ± 0.010	0.073 0.053	csk	
2	Fitting	0.250Inches	0.280		

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Date: _____

DQA: _____

QA Closed: _____

Date: _____

DISPOSITION	Work Order: _____	☐ Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved
	Part No. _____	
	NCR No. _____	
	Date: _____	

Step #:	Date:
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Description Work Order Deviation

Root Cause	
☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ OTHER :	☐ Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified

☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter

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Date: 06/16/18

DART
AEROSPACE
Container No: S081664

Part: D4292 - 1
Job No: 178115
Serial No/Batch: S081664
Revision:
Inspector:
Exp Date:
Instructions:

☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Mistread ☐ Turning Sequence
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☐ Engineering ☐ Quality ☐ Other	MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval
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AGAINST DEPARTMENT/PROCESS

Water lot

Cross tube

Skid-tube

DART AEROSPACE LTD		Work Order: 178115
Description: Fitting		Part Number: D4292-1
Inspection Dwg: D4292 Rev: C		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.063	+/-0.010	.063	✓		Rad gauge	
0.250	+0.030/-0.010	.257	✓		SLIO	Veru
0.125	+0.030/-0.010	.132	✓			
2.95	+/-0.030	2.950	✓			
0.275	+/-0.010	.275	✓			
0.800	+/-0.010	.801	✓			
0.825	+/-0.010	.825	✓			
0.375	+/-0.010	.375	✓			
0.31	+/-0.030	.312	✓			
0.88	+/-0.030	.880	✓			
0.663	+/-0.010	.663	✓			
Ø0.381	+0.000/-0.001	.380	✓			
1.125	+/-0.010	1.125	✓			
1.063	+/-0.010	1.060	✓			
3.44	+/-0.030	3.438	✓			
2.450	+/-0.010	2.451	✓			
1.325	+/-0.010	1.326	✓			
0.300	+/-0.010	.300	✓			
1.200	+/-0.010	1.200	✓			
2.84	+/-0.030	2.835	✓			
0.19	+/-0.030	.189	✓			
5.86	+/-0.030	5.857	✓			
5.99	+/-0.030	5.990	✓			
Ø0.272	+0.006/-0.001	.272	✓			
Ø0.266	+0.006/-0.001	.266	✓			
1.75	+/-0.030	1.752	✓			
R0.25	+/-0.030	.250	✓		Rad gauge	
R0.06	+/-0.030	.060	✓		"	
4.875	+/-0.010	4.875	✓		SLIO	Veru
0.493	+/-0.010	.492	✓			
C-bore Ø0.765	+/-0.010	.765	✓			
0.250	+0.030/-0.010	.257	✓			
0.680	+/-0.010	.677	✓			
2.250	+/-0.010	2.250	✓			
4.500	+/-0.010	4.500	✓			
R1.275	+/-0.010	1.275	✓		Rad gauge	
R0.031	+/-0.010	.031	✓		"	

